

Date: Friday, 09/01/2009 8:23:11 AM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LUG ASSEMBLY
Job Number :	44521		
Estimate Number :	11745		
P.O. Number :		Part Number :	D3394043
This Issue :	09/01/2009	Drawing Number :	D3394 REV A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	A
Previous Run :	43388	Material :	
Written By :	<i>W</i>	Due Date :	21/01/2009
Checked & Approved By :	<i>C 09/01/09</i>	Qty:	50
Comment :	Est Rev: A New Issue 06-01-06 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
-----	-------	---------------



Comment: Qty.: 0.0735 f(s)/Unit Total : 3.6750 f(s)

D2423 Lug Extrusion

Batch: *B43722*

C 09/01/09 (50)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut Blank to .850"

cut 0 meter

3.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------



Comment: Sub-Contracting OUTSIDE SERVICES

Send Blanks To: Metec/Mast Precision Machining

P/O: *89 7934*

Machine D3394-3 as per Dwg D3394

C 09/01/09 (50)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

C 9/01/22 (50)

5.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

S 02/01/22

counters

(50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: -Friday, 09/01/2009 8:23:11 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 44521

Part Number: D3394043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(50)

AWM 9-1-23

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



(50)

m 109996

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:00

OVEN TEMPERATURE:

320°

FINISH TIME:

11:30

FL 09/01/26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-26

9.0

MS3548993

GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS35489-93	Grommet	M106168

M106168

SS

09/01/28 (50)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3394

EB 09/01/29

(50)

11.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

S 09/01/29

(50)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



(50)

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 413

9/2/2

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 44521

Part Number: D3394043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

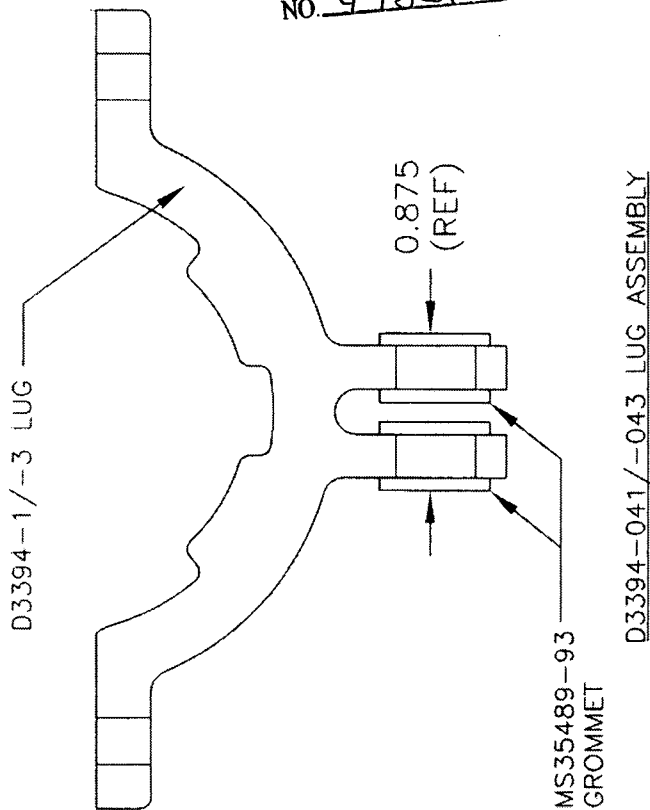


U. G. A. 02

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3394	REV. A SHEET 1 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1
A	05.02.14	NEW ISSUE	

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WITHOUT NOTICE
WORK ORDER
NO. 44521



PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY

QTY -		PART NUMBER	DESCRIPTION
041	043		
X		D3394-041	LUG ASSEMBLY
	X	D3394-043	LUG ASSEMBLY
1		D3394-1	LUG
	1	D3394-3	LUG
2	2	MS35489-93	GROMMET

RELEASED

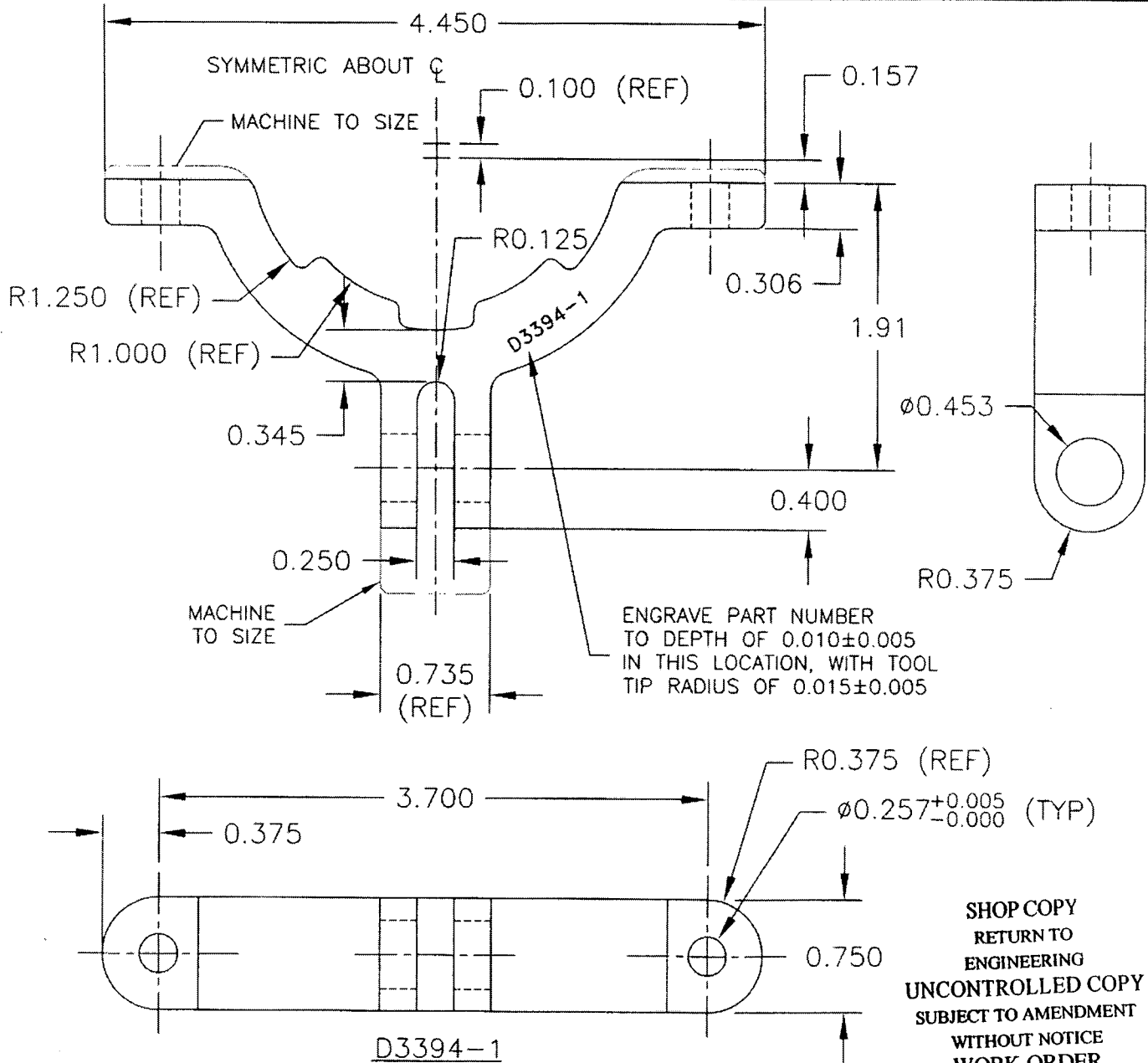
05.11.14

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DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 05.02.14		TITLE LUG	SCALE 1:1



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05.11.14

D3394-1 NOTES

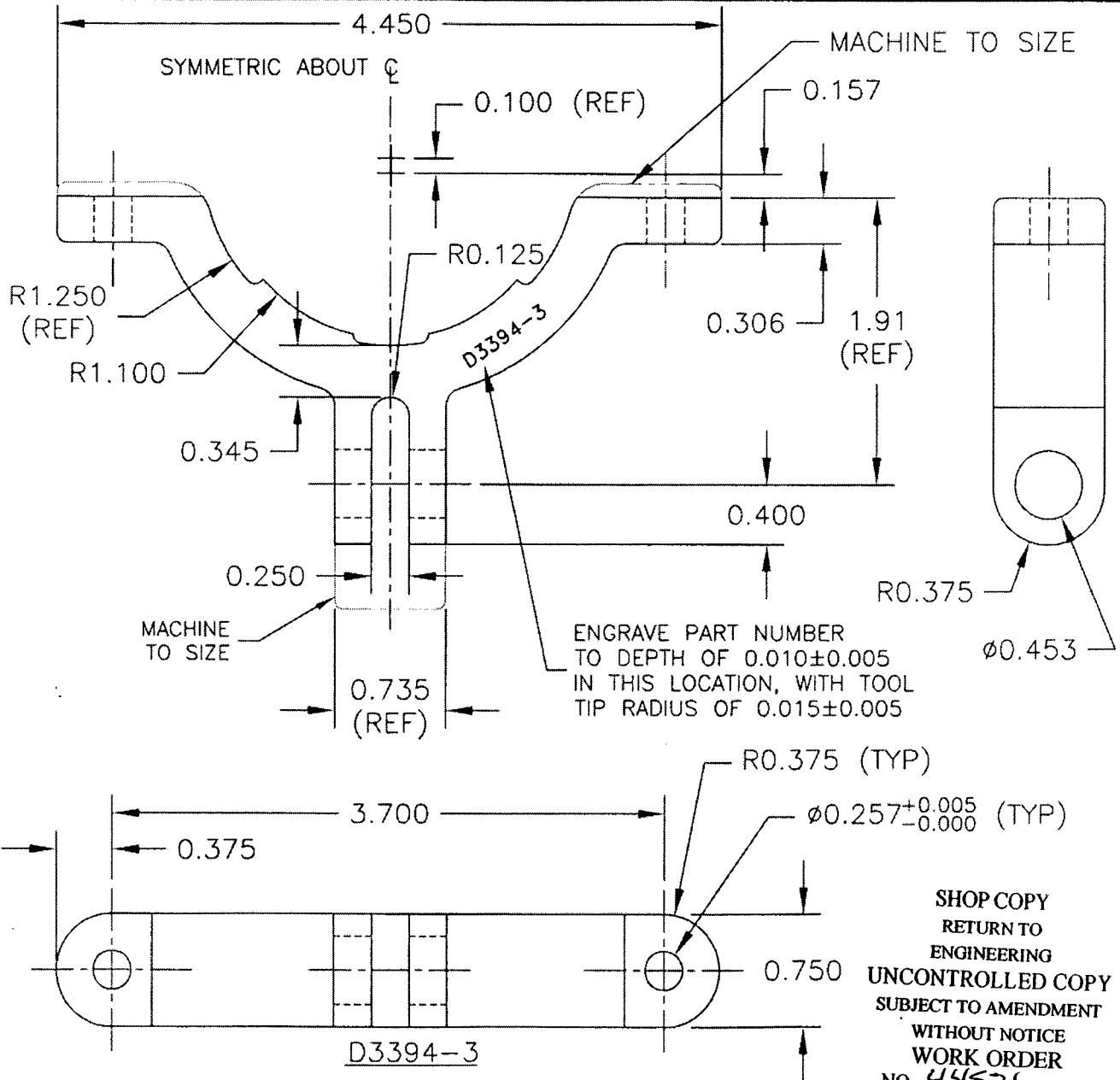
- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3394	REV. A SHEET 3 OF 3
DATE 05.02.14	TITLE LUG		SCALE 1:1



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WORK ORDER
NO. 44521

RELEASED

05-11-14

D3394-3 NOTES

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CERTIFICATE OF CONFORMITY

SHIPPED TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

50

D3394-3

Mounting Lug

7934

MATERIAL: supplied by DART D2423 B43722

S 0910122

We hereby certify that the above parts were made in conformance with applicable drawings.

MITEC Metal Technology Inc.


Denise Robinson

Vankleek Hill, January 23, 2009